

Date: Wednesday, 06/09/2006 11:05:14 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SUPPORT ARM
Job Number : 28421	
Estimate Number : 12515	
P.O. Number : N/A	Part Number : D35271
This Issue : 06/09/2006 S.O. No. : N/A	Drawing Number : D3527 UNDER REVIEW <i>06.09.05</i>
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : UNDER REVIEW
Previous Run : N/A	Material : N/A
Written By : <i>EC</i>	Due Date : 13/09/2006 Qty: 2 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est Rev:A New Issue 06-08-28 EC	

Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M006T6T0375W035	6061-T6 Tube .375 x.035W
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M304 TR0375W035



Comment: Qty.: 0.3885 f(s)/Unit Total: 1.5540 f(s)

M304 Tube

6061-T6 Tube .375 x.035W

Batch: N18993

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1-Cut tube 4.375" long

2-Press ends and drill as per dwg D3527

3-Bend ends as per dwg D3527

4-Deburr

SB 06/09/06

(2)

3.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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**Comment:** HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*N/A**P10*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: *P* Date: *26/08/14*
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 06/09/2006 11:05:15 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT ARM

Job Number: 28421

Part Number: D35271

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

FC 06 09 13 2

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



NOT REQUIRED FOR TESTING
CB 07.07.20



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 51447

06/09/14 2

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: Inspection Level 21

06/09/14

Job Completion



u 06/09/14

ENG APPROVAL

PART INSPECTED AFTER INSTALLATION
PART OK FOR TESTING ONLY

CB 07.07.20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	*Sign & Date			

NOTE: Date & initial all entries

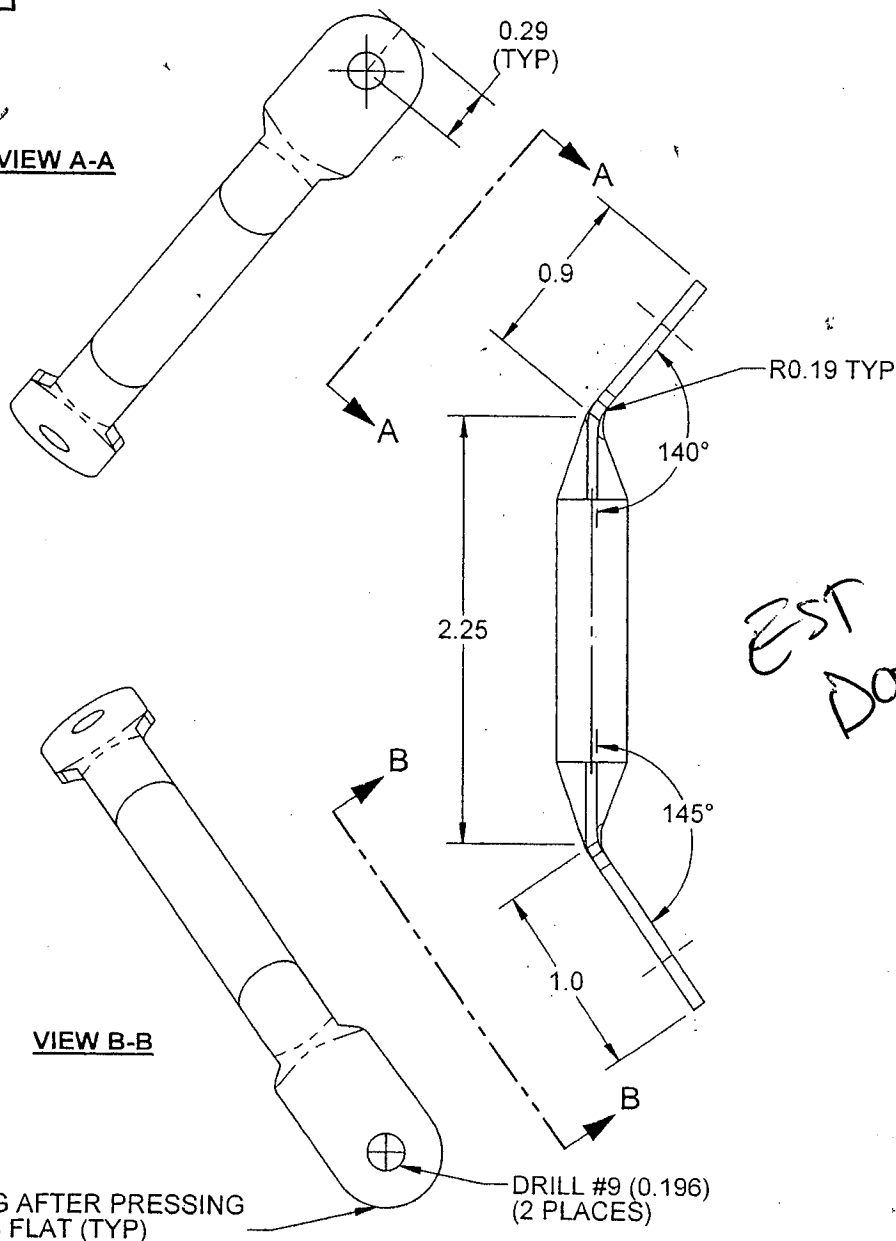
PRELIMINARY ISSUE

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3527	REV. A
DATE 06.05.02		TITLE SUPPORT ARM	SHEET 1 OF 1
A	06.05.02	NEW ISSUE	SCALE 1:1

UNDER REVIEW

OG-08.22 CB
prototype

VIEW A-A



VIEW B-B

ROUND LUG AFTER PRESSING
TUBE ENDS FLAT (TYP)

DRILL #9 (0.196)
(2 PLACES)

D3527-1 SUPPORT ARM

NOTES:

- 304 Stainless Steel
- 1) MATERIAL: ~~6061-T6 ALUMINUM TUBE (QQ-A-200/8 OR QQ-A-225/8)~~ 0.375 OD, 0.035 WALL (REF DART SPEC. M6061T6T0.375W.035)
 - 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) ALL DIMENSIONS ARE IN INCHES
 - 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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